

# Work Order ID 126246

Tuesday, November 04, 2014 10:23:09 AM

649.5210  
B126246  
REV-A

\*126246\*

Page 1

Item ID: 649.5210

Revision ID:

Item Name: Doubler

Start Date: 11/4/2014 Start Qty: 12.00

Required Date: 11/4/2014 Req'd Qty: 12.00

Reference:

\*12\*

\*12\*

\*N900040100\*

Cust Item ID:

Customer:

Setup Start \*NS1\*

Stop \*NS2\*

Approvals: Process Plan: MCS Date: 11-11-04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
649.5200	A								

110

0.00

\*110\*

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

(12)

Dec 14/11/16

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Quality Control

Memo

0.00

(12)

DAS  
50  
9-89

Dec 14/11/16

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Doc/Data									
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**Work Order ID 126246**

Tuesday, November 04, 2014 10:23:09 AM

**\*126246\***

Page 4

Item ID: 649.5210

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Doubler

Start Date: 11/4/2014 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 11/4/2014 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg & Stock Location: ck 125

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

\*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV\*\*\*

1214/11/26

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

14/12/2611-27

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Picklist Print

Tuesday, November 04, 2014 10:23:12 AM

Page 1

Work Order ID: 126246

**\*126246\***

Parent Item: 649.5210

**\*649 5210\***

Parent Item Name: Doubler

Start Date: 11/4/2014

Required Date: 11/4/2014

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 13.01.10 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.125

Purchased

No

110

sf

61.5000

0.06

1

**\*M2024T3S 125\***

2024-T3 .125 sheet

**\*\***

pc 14/11/16

Location

Loc Qty

Loc Code

MAT022

61.5

M127668

61.5

1.4339

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03696				SHEET 1 OF 1	
	DWG NO. 649.5200	REV: A	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: BRACKET					
APPROVED BY: ENGR <i>JEL</i>		MFG <i>Daniel Barber</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE MATERIAL.			ECR: D-12-004 SHIP COPY RETURN TO ENGINEERING	

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 126246 MJS  
14-11-04

### SHEET 1, ZONE A2 IS:

IS

⚠ MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.

IS

⚠ ALTERNATE MATERIAL: 0.125 INCH THICK 2024-T3 ALUMINUM SHEET METAL.  
⚠ ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

### SHEET 1, ZONE B1 IS:

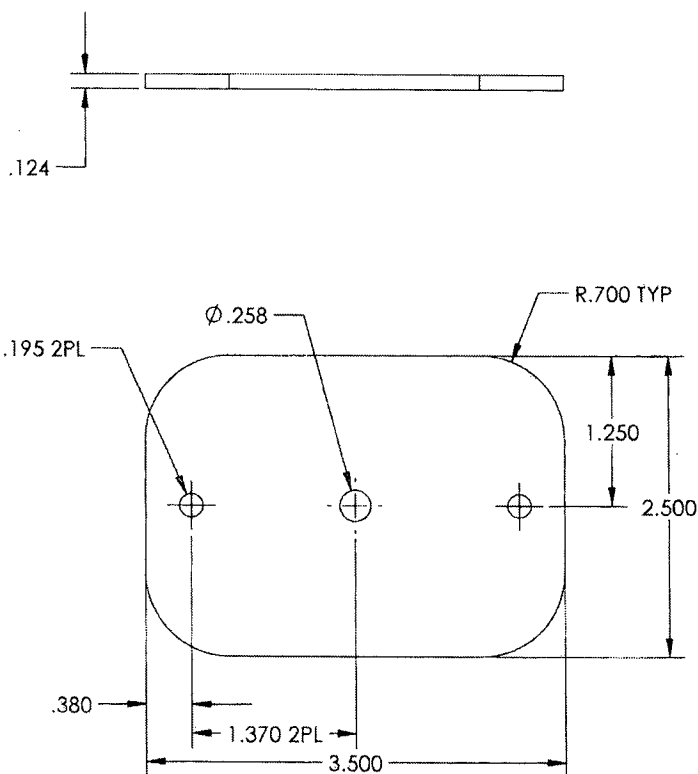
5	R	649.5214			BRACKET	⚠ ⚠	⚠ ⚠
4	R	649.5213			DOUBLER	⚠ ⚠	⚠
3	R	649.5212			BRACKET	⚠ ⚠	⚠ ⚠
2	R	649.5211			SHIM	⚠ ⚠	⚠
1	R	649.5210			DOUBLER	⚠ ⚠	⚠
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM						<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO



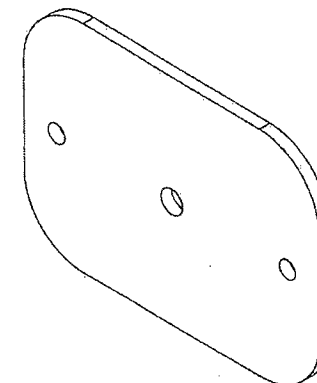
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NOTES: UNLESS OTHERWISE SPECIFIED

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2. COLOR: BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J TYPE I, CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ENGRAVE CENTURY GOTHIC, 12 POINT P/N AND REVISION.
- 5 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5212 BRACKET.SLDPRT, LAST MODIFIED 11-02-11.
- 6 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5214 BRACKET.SLDPRY, LAST MODIFIED 11-02-11.



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PP1		11/11
INC.	INITIAL RELEASE	11-02-11	P. BRAVO
A	INCORPORATED ECN 03408	04-17-12	P. BRAVO



649.5210

UNINCORPORATED ECN(s)

03696

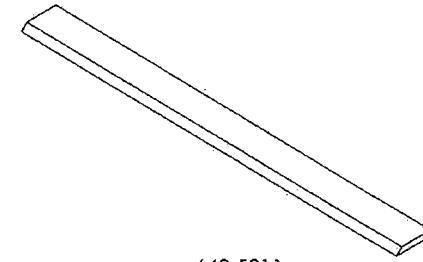
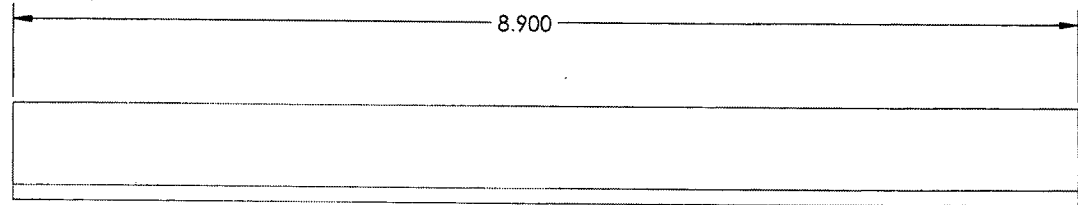
	5	649.5214	BRACKET	△	△△△
	4	649.5213	DOUBLER	△	△
	3	649.5212	BRACKET	△	△△△
	2	649.5211	SHIM	△	△
	1	649.5210	DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY	PARTS LIST				
NEXT ASSY (S)	APICAL INDUSTRIES				
649.4700	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300				
	BRACKET				
	UNLESS OTHERWISE SPECIFIED (DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°)	MFG	CAGE CODE	QNG. NO.	REV.
		B	07M16	649.5200	A
		SCALE NONE			SHEET 1 OF 4



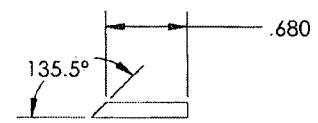
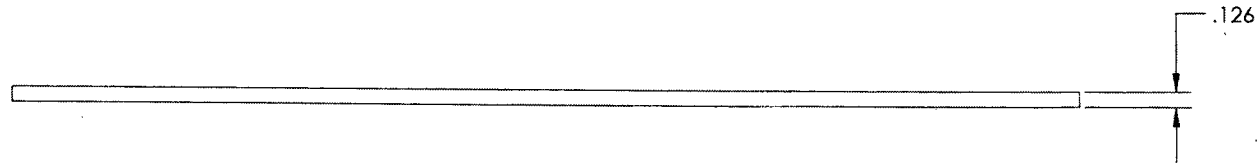
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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

A  
B  
C  
D



649.5211



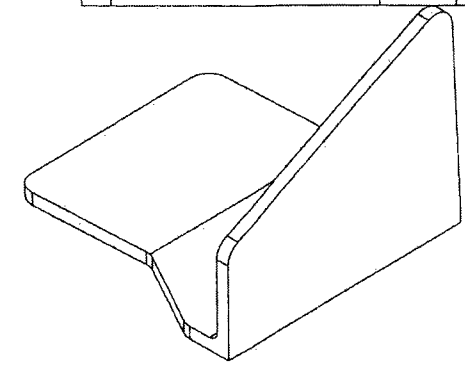
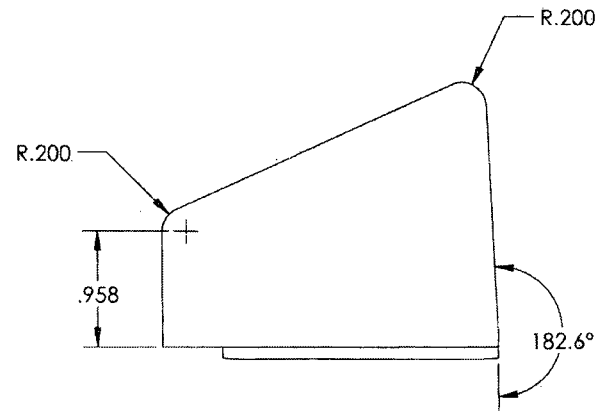
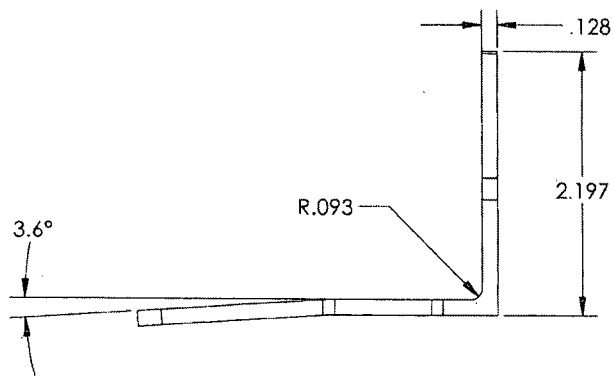
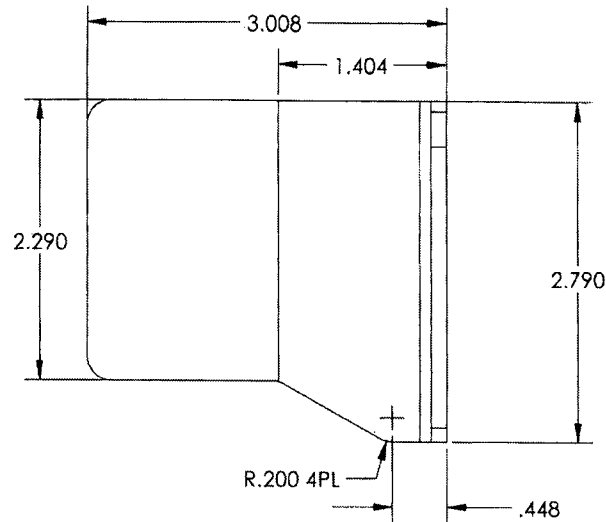
ORIGINAL DATE 11/02/11 DRAWN BY A. GUAN CHECKED BY P. BEAYO DRAWING APPROVAL 11/02/11 CONTRACT NO.		<b>APICAL INDUSTRIES</b> 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 <b>BRACKET</b>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°	SEE CAGE CODE B 07M26	DWG NO. 649.5200	REV. A
SCALE NONE		SHEET 2 OF 4	





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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



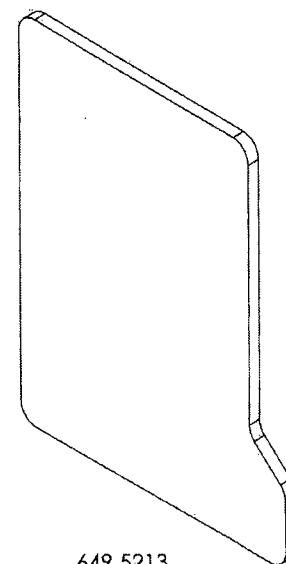
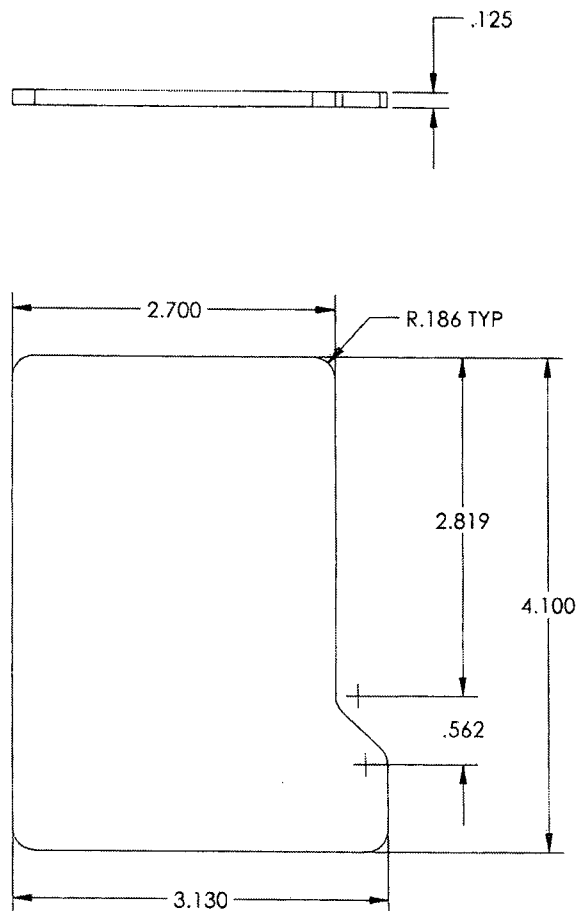
649.5212 SHOWN  
649.5214 OPPOSITE

ORIGINAL DATE (WCD-DA-10) 11-02-11		APICAL INDUSTRIES	
DRAWN BY A. QUINN	CHECKER J. BRAND	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL J. BRAND	11-02-11	BRACKET	
CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET 3 OF 4	REV. A



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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



649.5213

ORIGINAL DATE 2/20/04-121		1/02/11	
DRAWN BY A. OLSEN	CHECKED P. BRAVO	APICAL INDUSTRIES	
DRAWING APPROVAL P. BRAVO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACTING		BRACKET	
BRIEF DESCRIPTION SPECIFIC DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	REV A
CAGE CODE 07M16		DWG. NO. 649.5200	SCALE NONE
SHEET 4 OF 4		SHEET 4 OF 4	







ACE

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

**PURCHASE ORDER****Purchase Order ID PO26547****Purchase Order Date** 11/18/2014**PO Print Date** 11/19/2014**Page Number** 3 of 3**Order From :**

VC-ATG001

**Ship To :** DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.  
731 INDUSTRIELLE ROAD  
ROCKLAND, ON K4K 1T2  
CANADA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name****Vendor Phone**

613-446-4544

**Buyer**

Chantal Lavoie

**Customer POID****Customer Tax #**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

FCA - (Free Carrier)

**Ship To Contact****Ship To Phone****Ship Via:**

VENDOR'S TRUCK

**Ship Acct:**

6	126246	649.5210 DOUBLER	11/26/2014	12.00	\$7.40	\$88.8
			Yes			
			11/26/2014			

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

SP14-11-26

**Line Total:**

\$88.8

7	71401-45	procurement quality clauses	11/26/2014	1.00	\$0.00	\$0.0
			No			

**Procurement Quality Clauses**

A004 FAA-PMA /TSO

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A024 PROCESS CERTIFICATIONS

A025 CERTIFICATE OF CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

11/26/2014

**Line Total:**

\$0.0

**PO Total:**

\$1,272.0

W 62

**Note:** Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

**Change Nbr:** 2**Change Date:** 11/19/2014







A.T.G. Industries Inc.  
731, rue Industrielle Rd.  
PLATING DEPARTMENT  
Rockland, On K4K 1T2  
Canada  
Ph: (613) 446-4544  
Fax: (613) 446-4556

### Pack List

Number: 63406

Date: 26-Nov-14

#### To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

#### Ship To


DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	PRIME PER MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLIED BY CUSTOMER Job: 20140800 PO: 26547 Line:		
12 ea	Part: 649.5210 DOUBLER HARD ANODIZE BLACK TYPE III CLASS 2 PRIME PER MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLIED BY CUSTOMER Job: 20140801 PO: 26547 Line:	Rev:	8014-11-26.
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: 26/11/14</p> <p>CERTIFIED SIGNATURE: </p> <p>RECEIVER SIGNATURE: _____</p>			

